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D5336-041
Job Sheet 185733



Part No: D5336-041

Job Qty: 1 ea

Part Name: Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,3,7 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 AS PER REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	1 pcs		11/16/18	0.00	8.02	Large Fab 1		
110	QC	1 pcs		11/16/18	0.00	0.00	QC9		
120	QC	1 pcs		11/16/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs		11/16/18	0.00	0.11	Powdercoat4		
140	HandFinish	1 pcs		11/16/18	0.00	0.75	HandFinish3		
150	QC	1 pcs		11/16/18	0.00	0.00	QC3		
160	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea		11/16/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld hinge (3) and Mounting brackets as per dwg
Descriptions: D5336 ***inspect before welding mesh*** 3- Cut mesh as per dwg D5334-1 4- Tack weld mesh on basket as per dwg
D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

130 - *** Mask holes and sides of hinge prior to powdercoat*** Start Time: 8:15 Oven Temperature: 320°
Finish Time: 8:45

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 Ea (2 ea) ✓	90-Start up Operation	S 108 601
D4016-3 ✓	Hinge Half, Lid	3 Ea (3 ea) ✓	90-Start up Operation	S 121 277
D5332-041 ✓	Rib Assembly	2 Ea (2 ea) ✓	90-Start up Operation	S 127 093
D5332-1 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	S 090 552
D5332-13 ✓	Rib	3 Ea (3 ea) ✓	90-Start up Operation	S 117 495
D5332-15 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	S 090 600
D5332-19 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	S 090 577
D5335-1 ✓	Data Plate	1 Ea (1 ea) ✓	90-Start up Operation	F 163 096
M304EX0.75-16F	Expanded Metal Flat SS	8.1600 sf (8.16 ea)	90-Start up Operation	S 093684

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	42	0
	D4016-3	3	219	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

D5332-041	2	0	0
D5332-1	2	2	0
D5332-13	3	12	0
D5332-15	2	4	0
D5332-19	2	2	0
D5335-1	1	3	0
M304EX0.75-16F	8	1,189	0

Part Specifications

Specifications could not be found.

Plex 11/1/18 10:10 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____	Step #: _____	QTY Effective : _____				MRB (QSI042) Approval	
Description Work Order Deviation			Disposition			Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	

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Container No: S128794

Part: D5336 - 041

Job No: 185733

Serial No/Batch: S128794

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/18/18

ULT CATEGORY

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Misabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence